

Product Code:

| | |
|---------|-----|
| 440-508 | 10° |
| 440-320 | 20° |
| 440-098 | 40° |
| 440-028 | 90° |

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|-----------------------------|--------------------------|
| VISCOSITY: | 30±2 sec Zahn #4 at 25°C |
| FLASH POINT: | 27°C |
| DENSITY (kg/l): | 1.21 ± 2% at 25°C |
| SOLID (% by weight): | 67 ± 1% |
| SOLID (% by volume): | 53 ± 1% |
| SHELF LIFE (months): | 12 |

Product Description: Plasticolor White is an acid curing high-solids fast drying Reactive Amino Coating (RAC) with good building properties. This is a fast building product due to its high solid content (53% volume). It gives a smooth, knock-proof and hardwearing surface resisting influence from alcohol, water, etc.

Uses: Plasticolor White is used as the final coat over wood, plywood, chipboard, etc. meant for interior use. This product is recommended for kitchen cabinets, high build office or residential furniture as well as many other interior wood applications where high build and durability are required.

Environmental Data (as supplied):

| | |
|-------------------------|------|
| VOC less exempt lb/gal: | 3.34 |
| VOC lb/gal: | 3.34 |
| VOC less exempt g/l: | 401 |
| VOC g/l: | 401 |
| VOC lb/lb Solid: | 0.50 |
| VHAPs lb/lb Solid: | 0.36 |

See individual compliance sheets for specific data

Application Data:

| | |
|--------------------------------|---------------------------|
| SUGGESTED USES: | Spray |
| MIXING RATIO: | 10% 999-017 |
| POT LIFE: | 8 hours |
| APPLICATION VISCOSITY: | 20-25 sec Zahn #2 at 25°C |
| REDUCER: | 121-8020 or 121-803 |
| RETARDER: | 800-5328 EEP |
| CLEAN-UP SOLVENT: | Lacquer thinner |
| APPLIED FILM THICKNESS: | 3 to 5 mils wet |



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Directions for Use

Surface Preparation:

Primer should be sanded using #280/320 grit stearated paper before application of the topcoat and must be recovered within 8 hours after sanding. Care should be taken during sanding to avoid sanding through the primer. Plasticolor White must not be applied over metal, old oil finish or nitrocellulose lacquer.

General information:

Catalyze and reduce material as recommended. Contact with metal surfaces should be avoided once the Plasticolor White has been catalyzed. To ensure proper sheen, the catalyzed material should be agitated at all times. Plasticolor enamel must be thoroughly stirred, while adding hardener and reducers in the recommended ratio. Apply 3-5 mils wet on sanded surface. A subsequent coat can be applied after complete cure and a good sanding with a #280/320 grit paper is necessary to obtain a good adhesion. Dry film thickness of topcoat must not exceed 3 mils. Total dry film thickness of system should not exceed 6 mils.

Gloss Plasticolor may be rubbed and polished to a dirt free high gloss finish. Polishing methods should be discussed with your technical representative.

To obtain complete cure, the primer must be applied at a temperature above 18°C and relative humidity below 65%. When drying, this product is not to be exposed to ammonia vapors. Finished surface must not be cleaned with ammonia containing products.

Primers to use under 440-XXX: 220-005, 220-214, 220-2250, 225-001, 522-1410 and 522-1624.

THE CUSTOMER IS RESPONSIBLE FOR FOLLOWING THE RECOMMENDED APPLICATION PROCEDURES. FAILURE TO ADHERE TO THE RECOMMENDATIONS GIVEN IN THIS DATA SHEET WILL LIKELY RESULT IN UNSATISFACTORY FILM APPEARANCE OR FILM FAILURE. THE COMPLETE COATING SYSTEM SHOULD BE CHECKED FOR REQUIRED PROPERTIES PRIOR TO THE START-UP OF PRODUCTION.

Drying Times:

| | At 20°C (Minimum Required) | At 50°C (Minimum Required) |
|------------------------|----------------------------|--------------------------------|
| Tack Free Time: | 30-45 min | Flash off before entering oven |
| Dry to Sand: | 90-120 min | 45-60 min |
| Dry to Stack: | 12 hours | 2 hours |

Note: Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Temperatures are based on actual board temperature. This may vary depending on length of time for boards to reach these temperatures. Minimum curing temperatures of 64°F/18°C must be maintained throughout the curing cycle to achieve the film integrity as stated in product features.

These products are designed for industrial use only. AkzoNobel views safety as a top priority. Please refer to Material Safety Data Sheet for information on the safe use of this product.

Values shown are calculated estimates and should not be construed as product specifications. We cannot anticipate all conditions under which this information and our products or the products of other manufacturers in combination with our products may be used. We accept no responsibility for results obtained by the application of this information or the safety and suitability of each such product or product combination for their own purposes. Unless otherwise agreed in writing, we sell the products without warranty, and users assume all responsibility and liability for loss or damage arising from the use of our products whether used alone or a combination with other products. Use of unapproved or reclaimed solvent blends may reduce film properties and is not recommended.